

Work Order ID 161341

Thursday, May 11, 2017 3:03:21 PM

647.3804
B-161341
REV. N/C

161341

Page 1

Item ID: 647.3804

Revision ID:

Item Name: Lower Cutter Assembly High

Start Date: 6/1/2017 Start Qty: 3.00

Required Date: 6/6/2017 Req'd Qty: 3.00

Reference: SCHEDULED/C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: DAS 21 Date: MAY 11 2017

QC: 9-88 Date: SPC (Y/N):

Tooling:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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647.3800	n/c
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110	Pick Kit	0.00							
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110

Packaging

Memo

0.00

Packaging

17/1/16
DAS 6
9-88

120		0.00							
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120

Small Fab

Memo

1.14

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598:

exp. date: 02/17

137353

5x
17/06/08
DAS 36
9-88

130	QC5- Inspect part completeness to step on W/O	0.00							
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130

QC

Memo

0.06

Quality Control

5
JUN 12 2017
DAS 36
9-88

Work Order ID 161341

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Item ID: 647.3804 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assembly High
Start Date: 6/1/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 6/6/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location <u>CSK 2027</u>	0.00							
140									
Packaging	Memo	0.03							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.30							
Quality Control									

17/6/1342

DAS
21
9-89

JUN 1 2 2017

Picklist Print

Thursday, May 11, 2017 3:03:23 PM

Work Order ID: 161341

161341

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assembly High

Start Date: 6/1/2017

Required Date: 6/6/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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646.9701		Manufactured	No			110	Each	0.0000	1	3			
646.9701									**	160720x4	160771x4	DAS 6 9-89	

Cutter Sub Assembly

NAS1149FN832P

Purchased

No

110

Each

2,072.000

6

1830

NAS1149FN832P

Washer

DAS 6 9-89 JUN 1 2017

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST263

1714

M137412

1714

30

MS21042L08

Purchased

No

110

Each

1,059.000

3

915

MS21042L08

Nut

DAS 6 9-89 JUN 1 2017

Location

Loc Qty

Loc Code

GA

108

m135274

6

m135978

102

ST303

951

m137320

51

m137391

600

m137464

300

15

Picklist Print

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Work Order ID: 161341

161341

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assembly High

Start Date: 6/1/2017

Required Date: 6/6/2017

Start Qty: 3.00

Required Qty: 3.00

MS27039-08-19

Purchased

No

110

Each

448.0000

3

MS27039-08-19

Screw

**

DAS
6
9-89
JUN 01 2017

Location

Loc Qty

Loc Code

GA

30

m135948

26

m137178

4

over006

200

m137464

200

ST277

218

m137320

18

m137361

200

15

647.3902

Manufactured

No

110

Each

0.0000

1

3

647.3902

Lower Deflector Assembly, High

**

16173N3

162159X2

DAS
6
JUN 01 2017

Thursday, May 11, 2017 3:03:24 PM

Shop Packet Print

Page 2

				1	9	647.3911	212 UPPER DEFLECTOR			
				1	8	647.3910	412 UPPER DEFLECTOR			
	A/R	A/R	A/R	A/R	7	601.2045	RTV. LOCITE 598			
	I				6	647.3902	LOWER DEFLECTOR ASSY HIGH			
		1			5	647.3901	LOWER DEFLECTOR ASSY LOW			
	3	3	3	3	4	601.2765	SCREW	M527039-081P		
	3	3	3	3	3	601.1541	LOCKNUT	M521042-08		
	6	6	6	6	2	601.2764	WASHER	FIAS1145FNBSZP		
	1	1	1	1	1	646.9701	CUTTER SUB ASSY			
	X	X	X	X		647.3804	LOWER CUTTER ASSY HIGH			
	X	X	X	X		647.3803	LOWER CUTTER ASSY LOW			
	X	X	X	X		647.3802	212 UPPER CUTTER ASSY			
	X	X	X	X		647.3801	412 UPPER CUTTER ASSY			
	.3904	.3803	.3802	.3801	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
	QTY									
	NEXT ASSY (\$)									
	647.3700									

ORIGINAL DATE _____ CUS/MDP _____
 DRAWN BY _____ CHECKED _____
 J. JACKSON D. BAKER
 PROJECT APPROVAL _____
 BRATED _____
 CONTRACT NO. _____

OTHERWISE SPECIFIED OTHERWISE ARE CLEARLY IDENTIFIED BY THE PRINTER OR SHALL BE PLACED ON SEPARATE SHEET OF PAPER.

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA 92056-3512 (760)724-5303

CUTTER ASSY

GIF CASE CODE DWG NO. **647.3800** REV N/C

B D/M/LZ SCALE NONE SHEET 1 OF 1